

Date: Thursday, 29/05/2008 1:51:13 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEAR PLATE
Job Number :	39578		
Estimate Number :	11231		
P.O. Number :		Part Number :	D2348
This Issue :	29/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2348 REV B2
First Issue :	//	Project Number :	N/A
Previous Run :	38811	Drawing Revision :	B2
	Type :	Material :	
	SMALL /MED FAB	Due Date :	05/06/2008
Written By :		Qty:	50
		Um:	Each
Checked & Approved By :	<u>mf 08-05-29</u>		
Comment :	Est Rev A Removed from 9 Digit 05-12-05 JLM		
	Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 0.0208 sf(s)/Unit Total : 1.0395 sf(s)

Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)

Batch: 107387 B 8-5-30

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2348

Dwg Rev: B2

Prog Rev: B2

B 8-5-30

(62)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

50805130 x62 countes

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

EP 08/05/30 (62)

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Drawing Name: WEAR PLATE

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Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

S 08/05/30 (+62)

7.0

OUTSIDE SERV.20

OUTSIDE SERVICE - SF



Comment: Sub-Contracting PURCHASING

Issue P/O: 6520

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

C 08/06/06

(62)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

S 08/06/19 (62)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

INSPECT CERTS

S 09/06/20 (+62)

10.0

FE832EF

PEM-Insert



Comment: Qty.: 4.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 FE832EF PEM Insert

M108224 x100

M108313 x100

M108247 x148

S 08/06/23 (+62)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Insert as per Dwg D2348

S 08/06/23 (+62)

12.0

QC5

INSPECT WORK TO CURRENT STEP



count

Comment: INSPECT WORK TO CURRENT STEP

S 08/06/23 (+62)

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Part Number: D2348

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



62

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 27

8/6/23

50

14.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/25

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

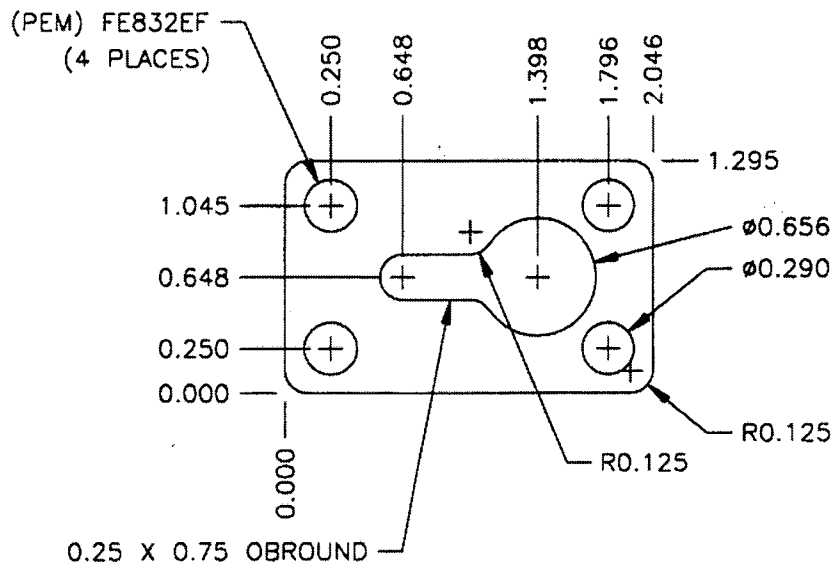


mf 08-06-25



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED	D2348	SHEET 1 OF 1
DATE	TITLE		SCALE
95:01:20	WEAR PLATE		1:1
B	95:02:20	CHANGED PEM INSERT TO 8-32	
B1	00:03:07	CHANGE TO AISI 304/316 MATERIAL	
B2	02:02:21	CHANGE BACK TO 6061-T6	

RELEASED
97/04/22 DS



- NOTES:
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 (M6061T6S)
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III/IV/VE CLASS 2
 - 3) INSTALL FE832EF INSERTS AFTER ANODIZING
 - 4) ALL DIMENSIONS ARE IN INCHES
 - 5) TOLERANCES ARE PER PART QSF 018 UNLESS OTHERWISE NOTED.

B 39578.

~~AISI 304/316 SS~~

~~MATERIAL: 6061-T6 ALUMINUM 0.063 THICK, ANODIZE BLACK
AFTER ANODIZING INSTALL (PEM FE832EF) 4 PLACES~~

I N M

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified
approuvé NADCAP approved

65597

11-Jun-2008

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE****NO. DE COMMANDE:
PURCHASE ORDER/**

6520



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	7	7	412-200-002-006 B39	DWG: D41232-200-002 REV. A
4	8	8	D3299-1 B38451	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2399 REV. B
2	62	62	D2348 B39578	BLUE ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
3	62	62	D2348 B39666	BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2 DWG: D2348 REV. B2
				BLACK ANODIZE PER MIL-8625F1, CLASS 2 TYPE 2

Last Modified on 20-Jun-2008

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed

Directeur de la Qualité / Q.A. Manager